

Work Order ID 111417

January-15-14 1:05:43 PM

111417

Page 1

Item ID: D3536-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket Center
 Start Date: 1/15/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 1/24/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1-20-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100 FLOW WATER JET 0.00
100 13 0 Jm14-02-20
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110 13 0 Jm14-02-20
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
120 13
 QC Memo 0.00
 Quality Control

DAS
27
9-89

4/2/21

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Item ID: D3536-25 Accept ***N900040100*** Setup Start ***NS1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>F12-001</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

x13 14-02-21

14-02-21

14-02-24

Picklist Print

Page 1

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Work Order ID: 111417

Parent Item: D3536-25

Start Date: 1/15/14

Required Date: 1/24/14

Parent Item Name: Gasket Center

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 NEOPRENE SHEET 0.063		Purchased	No			100	sf	44.1000	0.5956	7.9413336 9			Jm14-02-20

Location

Loc Qty

Loc Code

MAT052

44.1

M126546

44.1

128266

128266

DART AEROSPACE LTD		Work Order: 111417
Description: Gasket		Part Number: D3536-25
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80"	-		T	Jhm6
16.35	+/-0.030	16.35"	-		T	
10.90	+/-0.030	10.90"	-		T	
5.45	+/-0.030	5.45"	-		V	Jhm01
6.00	+/-0.030	6.00"	-		V	
6.75	+/-0.030	6.75"	-		V	
12.75	+/-0.030	12.75"	-		T	
1.89	+/-0.030	1.89"	-		V	
0.30	+/-0.030	0.30"	-		V	
0.30	+/-0.030	0.30"	-		V	
Ø0.19	+0.005/-0.001	0.19"	-		V	

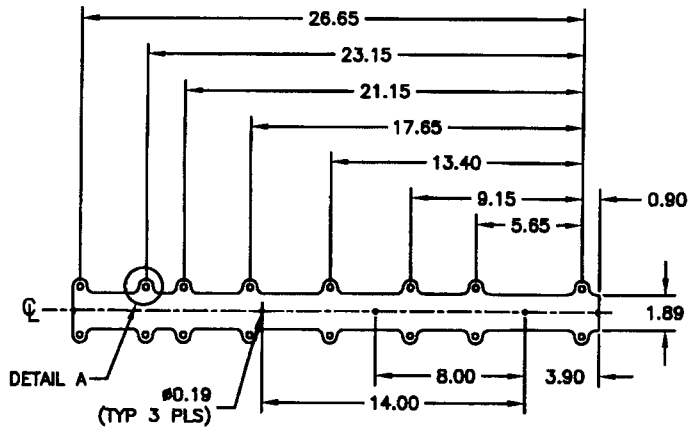
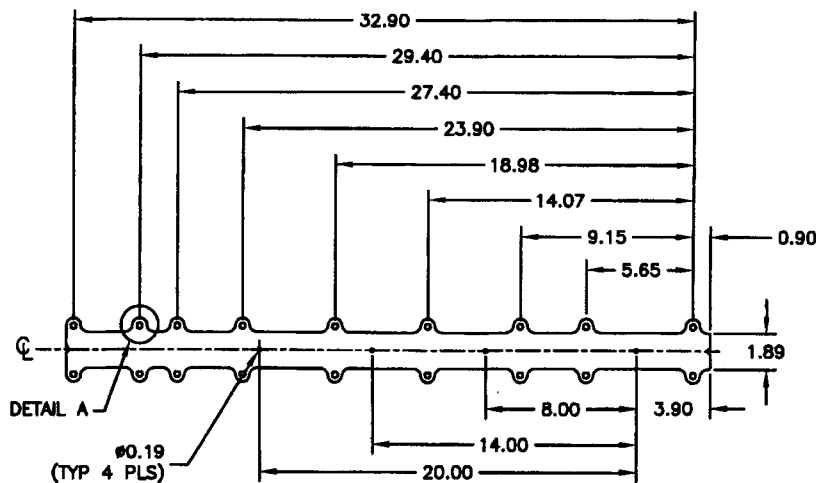
Measured by: Jm	Audited by: DAS 27 989	Prototype Approval:	N/A
Date: 14-02-20	Date: 14/02/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	E

DART

RELEASED

09-02-12-11

111417 MCL
14-01-16**D3536-11 GASKET****D3536-13 GASKET****NOTES**

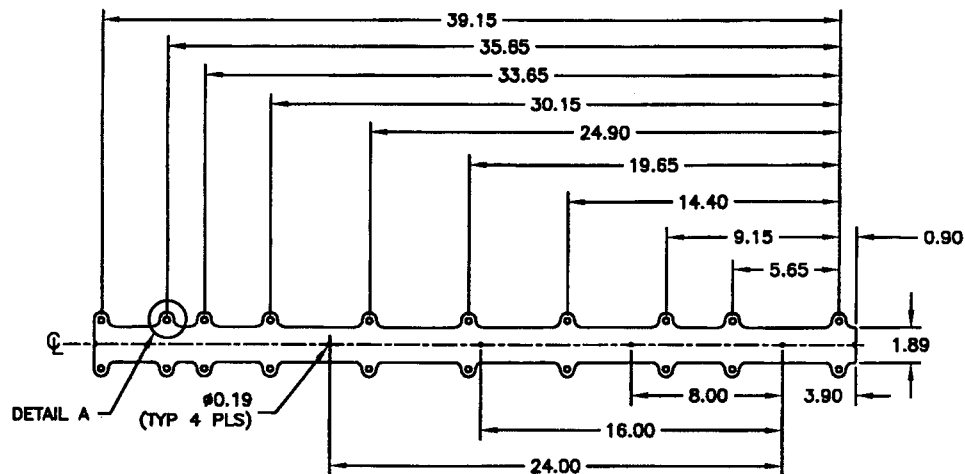
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3536
DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 1 OF 6
A	06.10.25	SCALE
	NEW ISSUE	1:10

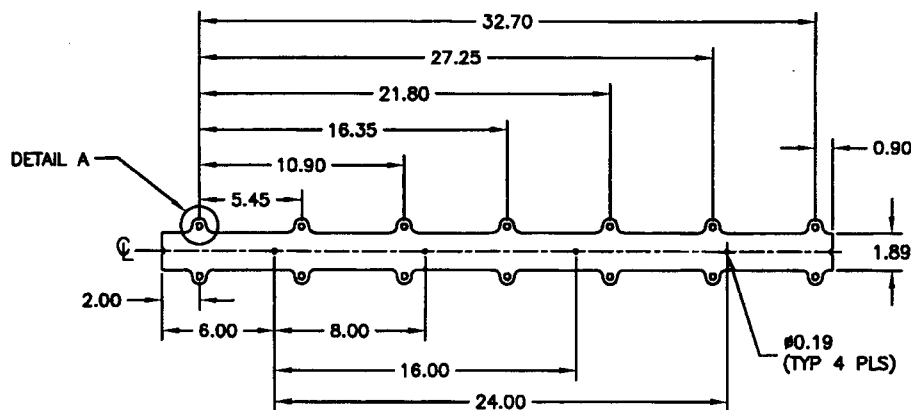


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		GASKET		SHEET 2 OF 6
				SCALE 1:10

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D3536-15 GASKET



D3536-21 GASKET

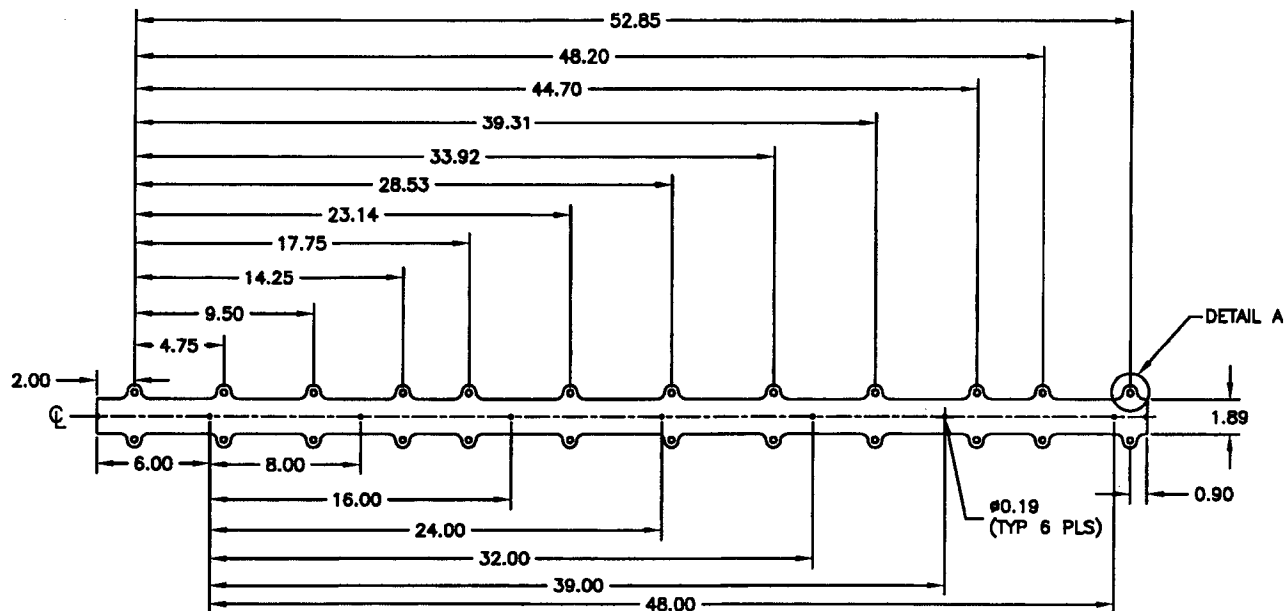
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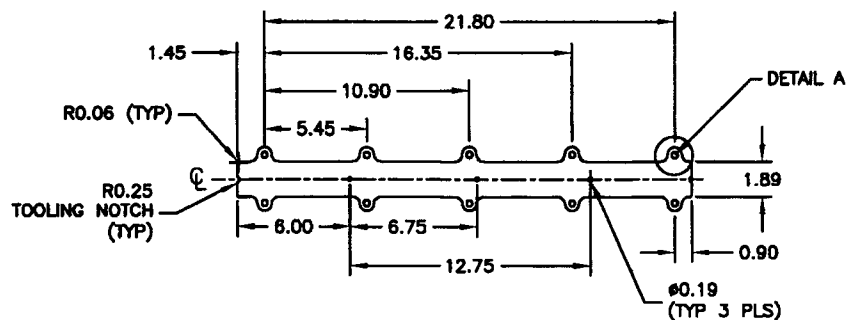


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		GASKET		SHEET 3 OF 6
				SCALE 1:10

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D3536-23 GASKET



D3536-25 GASKET

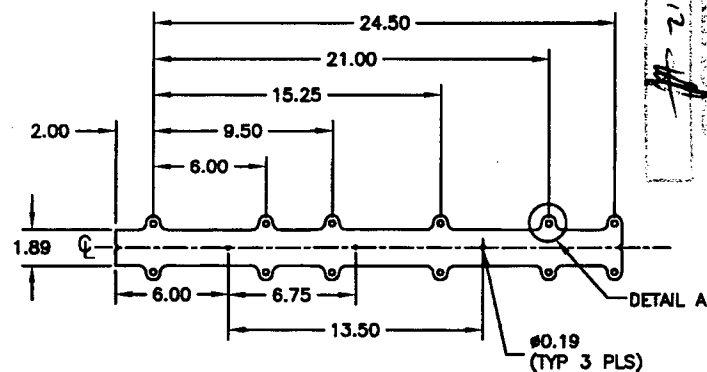
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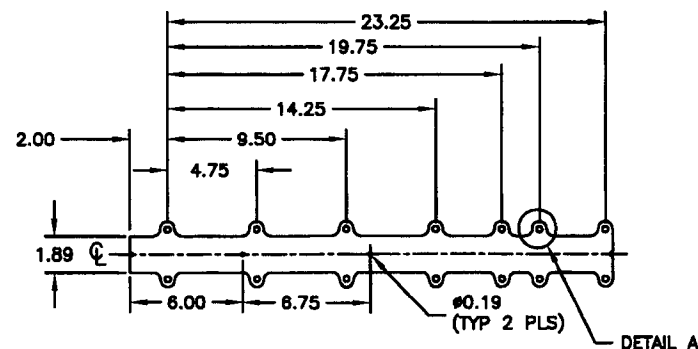
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				SCALE 1:10

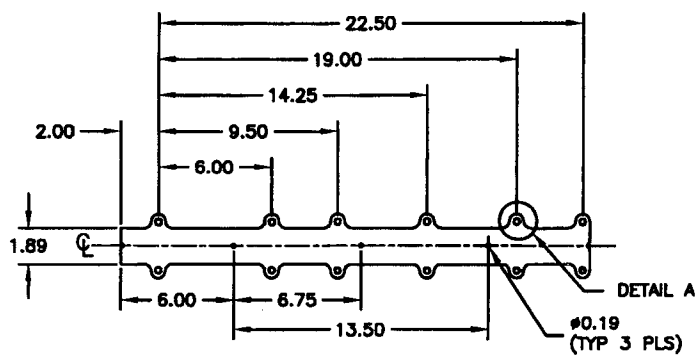
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D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

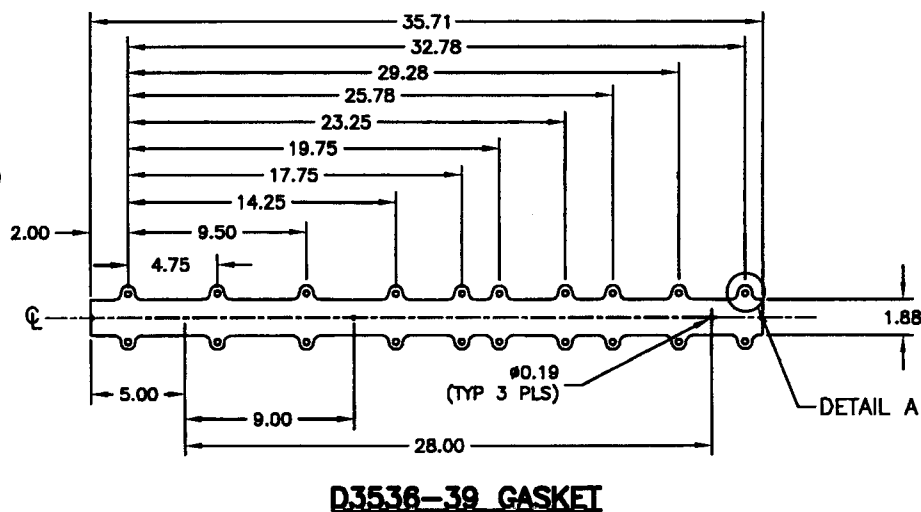
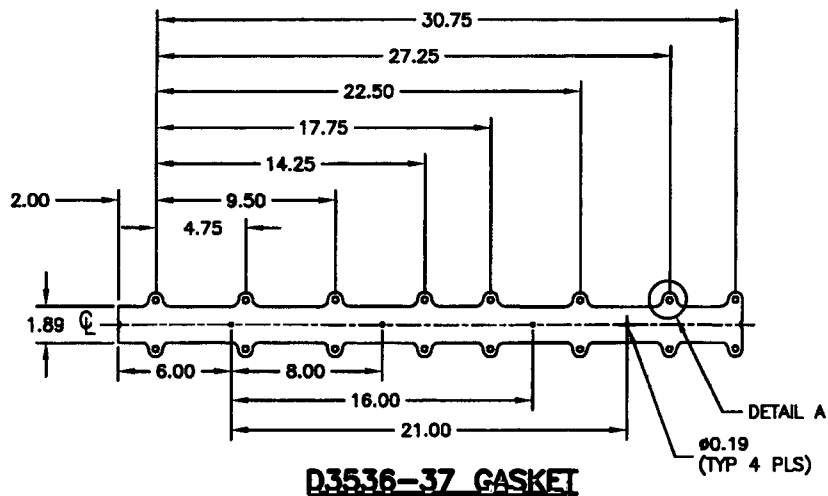
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07.02.12
PH



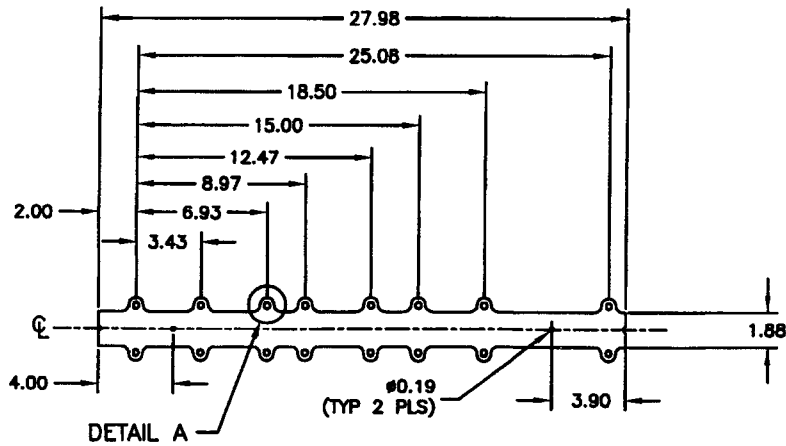
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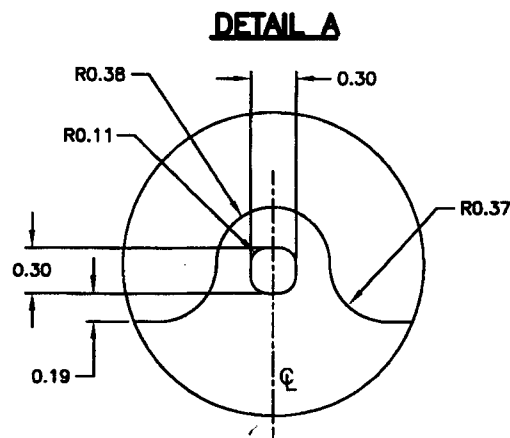
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		SCALE	1:10	



D3536-41 GASKET



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